## \*111739\*

Page 1

Monday, January	20, 2014 3:42:55 PM		**	17.59"						1 age 1
Revision ID:	D3440-7 Detent Clip Base (Supersedes	D67, 42001, 221)	Accept	*N900	<b>040</b>	100	)*	Setup Sta	171	S1*
•	• • • •	,							· ^IVI	S2*
Start Date: 1  Required Date: 1	1/20/2014 Start Qty: 1/31/2014 Req'd Qty:	• • • • • • • • • • • • • • • • • • • •		Cust Item II Customer:	D:					
Reference:	, h	<sup>12.00</sup> *12*		Customer:						
Approvals:	Process Plan:	Date: 14-1-20	_ Tooling:	Da	te:			Run Sta	~1 <i>\</i> J	R1*
	QC:	Date:	_ SPC (Y/N):	Da	te:			Sto	, *V	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				. **					
D3440	Rev A			•						
100 <b>*1                                    </b>	BAND SAW	emo	0.00 0.00	FX 14/01/2	3		12	Ø		
Jeaspa Bandsaw	Cu	t blank: 1.250" x 1.500" x 2.200" lo	0.00	St 14-01-25			ó8 08		•	2 7 5
*110*	HAAS CNC VI	ERTICAL MACHINING #1		FX 14/01/21	4		12	Ø		
HAAS 1 HAAS CNC vertical	machine #1 Ma	emo achine as per Folio FA537 and Dwg 8440-7Folio Rev:	0.00 ; D3440Dwg Rev: <u>A</u>	Identify as		Pto	)			· .
*120	QC2- Inspect p	arts off machine FAI/FAIB	0.00	FK 14/01/24	1		ح ا	. O		
QC Quality Control	M	emo	0.00	B. 14-01-25				; -		
		•								

DQA: <u>Ç</u>	A	$\frac{\mathcal{A}}{\mathcal{A}}$	Date: _	14/01	129	WORK OBDED NON	~~	NIEOI	DMANCE / LID	DATE			DART
QA Closed: (	W		Date:	141	1/29	WORK ORDER NON-	·CC	NFOI	RIVIAINCE / UP		ork Order up	date only	AEROSPACE
Work Orde	/ er:	1112	39	٠,	(	DISPOSITION				AGAINST DI	PARTMENT	PROCESS	
	- _ _	D34		7	_	Rework Scrap Use-as-is & Suspected Unapproved		1	Machining noforming	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering 🔀 Quality Other
Root Cause		Date	Step	Qty	Descr	ription of work order update or non-conformance		nitial ief Eng	Actic Descrip		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	4.	14:0127	NO	(Ζ	PB	PED HOLE NOT RPENDICULA R TO REFACE (@ 93°).	(4	0.27	ACCEPTANCE	DOWN	045 085 101/27 14/01/27	DAS 16 9-89	DAS 16 9-89 14101127
	·t						FAI	JLT CA	<b>TEGORY</b>				
Landi	ng G	ear	·····			General	FA	JLI CA	IEGORT				22222
		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning Se	k/Ripple t n Strip in atter	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set	ion Incomplete/Unditions Incomp	· —	Outside Dim Over/Under Part Incorree Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct sssing Vrong Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of	Sequence			····	

Work Order ID 111739

\*111739\*

Page 2

Monday, January 20, 2014 3:42:55 PM D3440-7 Accept Item ID: \*N900040100\* Setup Start **Revision ID:** Stop Detent Clip Base (Supersedes B67-43001-221) Item Name: \*19\* **Start Date:** 1/20/2014 **Start Otv:** 12.00 **Cust Item ID:** Required Date: 1/31/2014 Rea'd Otv: 12.00 \*19\* Customer: Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): OC: Date: \*NIP2\* Sequence ID/ Operation Set Up/ Reject **Tool ID** Tool# Plan Accept Reiect Insp. Work Center ID Description Number Stamp Run Hours Code **Qty** Oty 130 QC8- Inspect parts - second check 0.00 \*120\* OC 0.00 Memo **Ouality Control** Identify as per dwg & Stock Location: Mozz 2 140 DAS 12x 28 14-01-27 \*140\* Packaging 0.00 Memo Packaging 150 OC21- Final Inspection - Work Order Release 0.00 \*150\* MUJ 14-01-27 OC 0.00 Memo Quality Control

DQA:			Date:										DART
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / U	PDATE			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	<u> </u>
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIG	•			****		Rework	ıl	Ì	Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming	Finishing	4	e/Packaging	Other
NCR N	۱o. <sub>-</sub>					Suspected Unapproved	]		Large Fab	Composite	]	Supplier	
									······································				
Root		_	_		Desc	ription of work order update		nitial		tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process							l						z   2
Supplier													
Training	Н		1										
Transport	H								 				
Unapproved			j	1	<u> </u>		EA	IIIT CAT	TEGORY		<u>l</u>		
Landi	na G	Gear				General	- FA	OLI CA	LOOKI	——————————————————————————————————————			
Lanui	_	Bending				Bend	Г	leolio/P	rogram		Outside Dim	ensions [	Pressure/Forced
	-	Centre No	ot Concer	ntric	-	BOM/Route		Grain			Over/Under	<u>-</u>	Set-up
	<u> </u>	Cracks	000000			Broken/Damage/Defect		Hardwa	ire	<u> </u>	Part Incorred	<b>-</b>	Temperature/Cure
]	_	Cracks Crimp/Kink/Ripple/Wave				Burrs		-	ion Incomplete/U	ngualified	Part Lost/Mi	<b>⊢</b>	Weld
ļ	Cuffs Crimp/Kink/Ripple/Wave			,		Contamination		1 .	tions Incomplete/	· -	Part Moved	Ī	Wrong Stock Pulled
İ	Crushing				Countersink		4	ned/off center	<u> </u>	Positioned V	 Vrong	<b>_</b>	
		Heat Trea				Cut Too Short		Mislabe			Power Loss/		Other
	Inspection Strip in Tube Drawing				4		Misrea		L	_	_	•	
1	$\vdash$	Marks/Ch	•			Drill Holes		Off-set					
		Turning S				Finish		=	Calibration				
}	Wave/Twist in Tube					Fit/Function		Out of					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Monday, January 20, 2014 3:42:54 PM

Work Order ID:

111739

Parent Item:

D3440-7

**Parent Item Name:** 

Detent Clip Base (Supersedes B67-43001-221)

**Start Date:** 1/20/2014

Required Date: 1/31/2014

**Start Qty: 12.00** 

Required Qty: 12.00

**Comments:** 

IPP A05.06.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.250		Purchased	No			100	f	21.9420	0.1938	3	. •		
6061-T6 Bar 1.50 x 1.25													
				<b>Location</b>		Loc Oty	. <u>Lo</u>	c Code					
				MAT003		21.942							
				m12	27454	21.942			_3		F.K. 14	1011	23

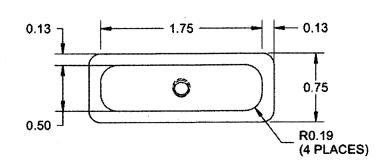
Page 1

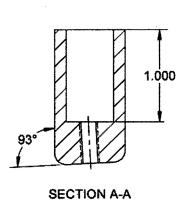
DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON		JNFOI	RIVIANCE / C		Vork Order up	odate only	AEROSPACE		
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS			
Part N	lo.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					Desci	ription of work order update	-1	nitial	A	ction	Sign &	,			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved															
			=				FA	ULT CA	regory			<del></del>			
Landi		Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch	nk/Ripple at n Strip in natter	/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misrea Off-set	ion Incomplete/ tions Incomplete gned/off center eled d	/Unclear	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	tolerance ct issing Wrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
-		Wave/Tu	-			Fit/Function		Out of Sequence							

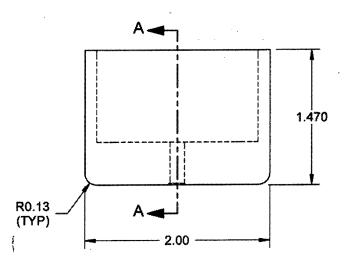


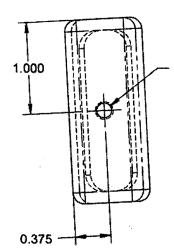
Г	ESIGN	DRAWN	BY	DART AEROSPACE	LTD
	4		3	HAWKESBURY, ONTARIO, CAN	
C	HECKĘD	APPRO	ĔΟ	DRAWING NO.	REV. A
	禄	1/1/1		D3440	SHEET 4 OF 7
٥	ATE		<u>.</u>	TITLE	SCALE
	C	5.06.02		BLADE FOLD KIT PARTS	1:1











DRILL Ø0.159 THRU, TAP #10-32 UNF THRU



## <u>D3440-7 DETENT CLIP BASE</u> SUPERSEDES PREMIER P/N B67-43001-221 NOTES:

1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DQA:		Date:									TRACT		
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAIN	IST DE	PARTMENT	PROCESS	
WOIR Old	• •				_	Rework	ı		Skid-tube Crosstu	he	1	Water Jet	Engineering
Part N	No.					Scrap			Machining Small F	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		1	noforming Finish		4	e/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab Compos	ite	]	Supplier	
Root				,	Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design						•							
Doc/Data													
Equip/Tooling													
Handling/Pre												:	
Material													
Operator	Ш	<b>.</b>											
Offset/Setup	<u> </u>												
Process	Н												
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Landi	ng (	Gear				General		,					
	Ŭ	Bending				Bend		Folio/	Program	Γ	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect	Г	Hardwa	are		Part Incorre	ci 🗀	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
		Cuffs Contamination				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	_
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	hatter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of Sequence					

DART AEROSPACE LTD	Work Order:	
Description: Detent Clip Base	Part Number:	D3440-7
Inspection Dwg: D3440 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1.744	7		FK-04	Vern.
0.13	+/-0.030	,128	>		h	
0.75	+/-0.030	.75	7		h	11
R0.19	+/-0.030	19	7		R - G	
0.50	+/-0.030	P. 8 PE.	8		FK-04	Vern
0.13	+/-0.030	.127	7		*	1
1.470	+/-0.010	1.471	7		11	4
2.00	+/-0.030	2.00	7		4	1
R0.13	+/-0.030	.13	7		R -G	
93°	+/-0.5°	92.8	7		A-G	
1.000	+/-0.010	1.000	7		サイと	Vern.
·						
					:	
					. '	
					-	

Measured by:	F.K.	Audited by:	Prototype Approval:	N/A
Date:	14/01/24	Date: /4-01-26	Date:	N/A

Rev	Date	Change	Revised by,	Approved
A 05	5.09.19	New Issue	KJ/JLM	

DQA:			Date:										
					~	WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	or.					DISPOSITION	ļ	i	AGAINST	DE	PARTMENT	PROCESS	:
Work Orac	-'' -				_	Rework	1 <b> </b>		Skid-tube Crosstube		]	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1 1		noforming Finishing		[	re/Packaging	Other
NCR N	۱o. <sub>-</sub>					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	• Description		Date	Verification	QC Inspector
Design													
Doc/Data							1						
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Handling/Pre			<b>₹</b>	•								فر بايس	
Material	Щ		,										
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Offset/Setup				·		•							
Process							İ						
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Training	Ш												
Transport	Ш			•	]				•				
Unapproved			<u> </u>	<u> </u>	<u> </u>		<u>L</u>						1
							FA	ULI CA	TEGORY				
Landi		1				<b>General</b> Bend		ارمانورا	Program		Outside Dim	onsions [	Pressure/Forced
		Bending	- <b>t</b> Camaan		$\vdash$	BOM/Route	$\vdash$	Grain	riogram	$\vdash$	Over/Under	<del> </del>	Set-up
	$\vdash$	Centre No	ot Concer	RITIC	$\vdash$	Broken/Damage/Defect		Hardw	370	-	Part Incorre		Temperature/Cure
	$\vdash$	Cracks Crimp/Kir	ak/Binnlo	Mayo	-	Burrs	$\vdash$	┨.	tion Incomplete/Unqualified	-	Part Lost/M	<u> </u>	Weld
	-	Cuffs	ik/kiphie	y wave	-	Contamination	$\vdash$	<b>-</b>	tions Incomplete/Unclear	$\vdash$	Part Moved	· -	Wrong Stock Pulled
	$\vdash$	Crushing			 	Countersink	-	4	gned/off center	$\vdash$	Positioned V		
	$\vdash$	Heat Trea			H	Cut Too Short		Mislab			Power Loss/	· -	Other
	$\vdash$	Inspectio		Tube	-	Drawing	$\vdash$	Misrea		<u></u>	]. 30. 2333/		1
	$\vdash$	Marks/Ch	•			Drill Holes	-	Off-set					
	$\vdash$	Turning S				Finish		-	Calibration				
	<u> </u>	Wave/Tw			<u> </u>	Fit/Function		-	Sequence				